

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012315**Date Inspected:** 22-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1230**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK

<b>CWI Name:</b>	N/A		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Component:</b>	Cable Band Castings		

**Bridge No:** 34-0006**Summary of Items Observed:**

The following report is based on METS Caltrans QA Inspector Mike Brcic's observations at Goodwin, International, Trentham, England, UK, on the above noted date and times.

**REPAIR WELDING**

~ GG29416-10 (B1-3-M) This QA Inspector observed welder Dan McDonagh, welder ID DM596, performing Shielded Metal Arc (SMAW) process, 4mm, E7018-1 electrode, in the 1G, flat position. Parameters of WPS 04-0120F4A issue 5, were verified and followed, Amp average during observation was 163, voltage was 24. Temperature of casting exceeded 170° Celsius (preheat) and was below 205° Celsius for an interpass temperature, these were the actual temperature limits verified by the use of temperature melting sticks. Travel Speed of a pass was approximately 205mm/min. Excavation in work was identified as #18R (weld build up), classified as "Minor", on the approved Weld Excavation Map.

**DIMENSIONAL REVIEW**

~WPP106~

B1 cable band, consisting of GG29416-3 and GG29417-2, has been presented to this QA Inspector. The following results were noted subsequent to QC inspector, Andy Cashmore, of GI completing his review.

GG29416-3, drawing 5540-B1-4-M

- Observed, was an area having been ground to a create a dip of, approximately 90mm in length in the 75mm

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radius, as seen in sectional view E-E. It is the intent of GI's Quality staff to grind the rather sharp edges of the "dip" to provide smooth transition in the 75 mm radius.

- Dimension #73, on the Dimensional Report, describes the required check as plug gauge check of 4 M22 holes, when in fact the casting only had 2 threaded stanchion holes to be verified. Administrative correction will be done by Mr. Andrew Cashmore, GI QC inspector.

GG29417-2, drawing 5540-B1-4-F

- The casting appeared to reflect actual dimensions as recorded by the QC personnel and otherwise meets the drawing and contract requirements.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

### Summary of Conversations:

No pertinent conversations occurred this day that this QA Inspector was a party to.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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